

Work Order ID 150529

Thursday, August 25, 2016 10:37:21 AM

150529

Page 1

Item ID: D5179-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 8/29/2016 Start Qty: 8.00

Required Date: 9/19/2016 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

AUG 25 2016

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5179	REV A								
100	FLOW WATER JET	0.02							
100									
Waterjet	Memo	0.01							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS
38
9-89

SEP 07 2016

Work Order ID 150529

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150529

Page 2

Item ID: D5179-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 8/29/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 9/19/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1
NC BRAKE

0.00

130

HandFinish

Memo

0.01

Hand Finishing

(x16) 6

2016/09/09

BETB

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.01

Quality Control

16

DAS
38
9-89

SEP 13 2016

150

Identify as per dwg & Stock Location: 5-220

0.00

150

Packaging

Memo

0.01

Packaging

16

DAS
9-89

SEP 14 2016

Work Order ID 150529

Thursday, August 25, 2016 10:37:21 AM

150529

Page 3

Item ID: D5179-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 8/29/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 9/19/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.13

Quality Control

DAS

21

9-89

SEP 14 2016

DAS

21

9-89

SEP 14 2016

Picklist Print

Thursday, August 25, 2016 10:37:25 AM

Page 1

Work Order ID: 150529

150529

Parent Item: D5179-3

D5179-3

Parent Item Name: Doubler

Start Date: 8/29/2016

Required Date: 9/19/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 15.05.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased		No			sf	91.4815		0.749474			
M6061T6S 0.32									**	<u>1.9</u>		<u>Dec 16 / 09 / 07</u>	
6061-T6 Sheet 0.032"													

Location

Loc Qty

Loc Code

MAT021

91.481497

m131352

48.1

m133757

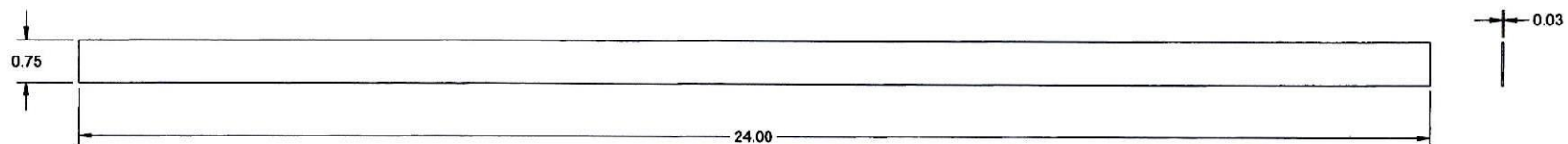
43.381497

.4

1.5

SHIP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

150529 MJ
1608-25



D5179-1 DOUBLER

RELEASED

2015 APR 30

ECN 15-521

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032"
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.0.32
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.06 lbs

APPROVED

A		NEW ISSUE		VS	14.10.27
REV.	DESCRIPTION			BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AK				
CHECKED	RF	DRAWING NO.	REV. A		
MFG. APPR.	DD	D5179	SHEET 1 OF 2		
APPROVED	HS	TITLE	SCALE		
DE APPR.	DS	DOUBLER	NTS		
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8 7 6 5 4 3 2 1

D

D

C

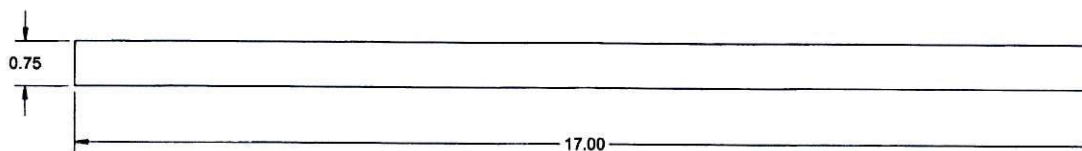
C

B

B

A

A



D5179-3 DOUBLER

RELEASED

2015 APR 30 *ap*

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032"
 QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027
 OR ASTM B209
 REF DART SPEC M6061T6S.0.32
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI044 6.1
- 7) WEIGHT: 0.04 lbs

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	DD	D5179	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
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8 7 6 5 4 3 2 1